User:

Tuesday, 4/4/2006 1:32:31 PM

Kim Johnston

## **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 26513

**Estimate Number** 

: 10827

P.O. Number

This Issue

Prsht Rev.

First Issue

**Previous Run** 

: N/A

: 4/4/2006

: N/A : 24897

S.O. No. : 1/A

: MACHINED PARTS Type

Part Number **Drawing Number** 

**Drawing Name** 

: D2877 : D2877 REV A

: SADDLE SPACER

**Project Number** 

: N/A **Drawing Revision** 

Material **Due Date**  : NOTE:1 BLANK MAKES 4 PARTS

: 5/5/2006

Qty:

120 Um:

Each

Written By Checked & Approved By

Comment

00.05.19 Added inspect level 8 EC

**Additional Product** 

Job Number:



Seq. #:

Machine Or Operation:

Description:

 $\omega_{\mathbf{q}} A$ 

M5052H32S100 1.0

5052-H32 .100 Sheet

Comment: Qty.:

2.0

65.6208 sf(s) 0.5468 sf(s)/Unit Total:

Material: 5052-H32/H34-(QQ-A-250/8) 0.100" Thick

Batch: M. 363

SHEAR

SHEAR

Comment: SHEAR

1 blank makes 4 parts

Blank: 7.00" x 4.25" (+0.030" 0.000")

HAAS CNC VERTICAL MACHINING #1

5-02



CUT 1-Machine per title D2877

INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC2

PARTS AS THEY COME OFF MACHINE

QC8 5.0

6.0

Comment: INSPEC

SECOND CHECK

Comment: SECOND CHECK

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

51

Deburr any rough edges after tumbling

JAD

06:05:09



Page 1

Form: rprocess

## **Dart Aerospace Ltd**

Dan Ae	OSpace L	tu .			•						
W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
							,				
Part No	:	PAR #: Fa	ult Category:	NCR: Ye	s No DQ	A: <u>S</u>	Date: <u> </u>	<u> </u>			
					N/C Close						
NCR:		WORK ORDER NON-CONF		ORMANCE (NO	CR)						
		Description of NC	Corrective Action	Section B	Vorisi	ootion :	A	A			

NCR:		\	WORK ORI	DER NON-CONFORMANC	E (NCR)				
		STEP Description of NC Section A		Corrective Action Section B	Verification	A	A		
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	
		·							
							-	İ	
No.				,					

NOTE: Date & initial all entries

Tuesday, 4/4/2006 1:32:32 PM Date: Kim Johnston User: **Process Sheet** Drawing Name: SADDLE SPACER Customer: CU-DAR001 Dart Helicopters Services Part Number: D2877 Job Number: 26513 Job Number: Description: Seq. #: **Machine Or Operation:** HAND FINISHING RESOURCE #1 HAND FINISHING1 7.0 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 8.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 9.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:\_ DOCUMENT CONTROL DC 10.0 Comment: DOCUMENT CONTROL Inspection Level 21 IN Dec08-12 Job Completion

Form: rprocess

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE			-	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
				•.	*.		٠.					
Part No	): 	PAR #:	Fault Cateo	gory:	_ NCR:	Yes N	lo <b>DQ</b> /	\:	Date:			
					(	QA: N/	C Closed	i:	_ Date: _			
NCR:			WORK ORDE	R NON-CONFORMA	NCE (	NCR)						
		Description of NC	Corrective Action Section B				Verification A			Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	ign &   Section			QC Inspector		
		10			İ							
										:		
					- 1		1		1	l		

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26513
Description: Saddle Spacer	Part Number:	D2877
Inspection Dwg: D2877 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

B!		Actual				
Drawing	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dimension						
0.98	+/-0.030	.98	V		Jern	
R0.06	+/-0.030	Q06	J		ROIUS GUAG	ne
R0.30	+/-0.030	R.03	V		Roius Guad	<b>Y</b>
1.00	+/-0.030	,994	J		Jern	
0.250	+0.030/-0.000		,			
Ø0.257	+0.005/-0.000	0.257 097			Jern Jern	
0.100 thick	+/-0.005	097	V		Jern	
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Measured by: | M | Audited by: | Prototype Approval: N/A |
Date: 06.05 06 | Date: N/A

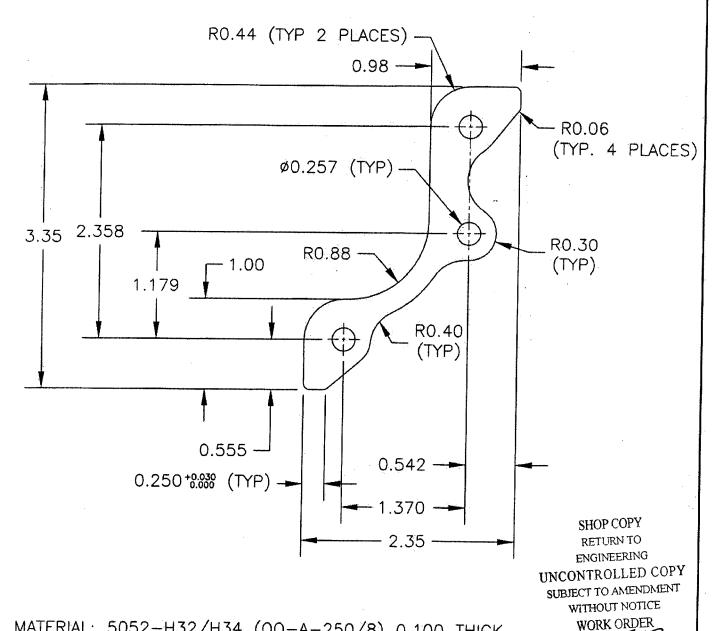
Rev	Date	Change	Revised, by	Approved
Α	04.01.21	New Issue	KJ/RF	·





				<u> </u>
	DESIGN P	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANADA	
	CHECKED	APPROVED	DRAWING NO.	REV. A
	_#	14	D2877	SHEET 1 OF 1
	DATE	<i>f</i>	TITLE	SCALE
_	99.02.23		SADDLE SPACER	1:1
	A	99 02 23	NEW ISSUE	

DELEASED (99.04.27 bs)



MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.100 THICK FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

BREAK ALL SHARP EDGES 0.010 TO 0.020